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DART
AEROSPACE

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RBE350A94-2706-00-09A
Job Sheet 180115

Part No: RBE350A94-2706-00-09A Job Qty: 30 ea

Part Name: Pin Shaft

Part Weight: 0 lbs Status: At Planning Priority: Medium

Job Created: 6/28/18 Job Tracking No:

Due Date: 7/30/18 Created By: Logan David

Type: SOLD Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-15 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs Hrs	Workcenter/Supplier	Sign-off
90	Start up Operation	30 Ea	7/30/18	7/30/18	0.00 0.00	Start Up Machining-3	JB 18-09-24
110	CNC Lathe	30 pcs	7/30/18	7/30/18	0.00 15.00	MORI SL-154	JB 18-09-24
120	QC	30 pcs	7/30/18	7/30/18	0.00 0.00	QC2 Machining-4	JB 18-09-24
130	QC	30 pcs	7/30/18	7/30/18	0.00 0.00	QC8 Machining-4	JB 18-09-24
140	Packaging	30 pcs	7/30/18	7/30/18	0.00 0.00	Packaging3-1	JB 18-09-24
150	QC21-SA	30 Ea	7/30/18	7/30/18	0.00 0.00	QC21	21 SEP 25 2018

Part Op 110 - 1-Machine as per DWG. FB738 FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave Dash

Descriptions: number Using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
88625K67	Dowel Pin Ø8mm x 40mm	30 ft (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	88625K67	30	36	0

Part Specifications

Specifications could not be found.

10/24

DAS 62 9-89 GA

DAS 13 9-89

P10:040421



Container No: S113152



Part: RBE350A94-2706-00-09A

Job No: 180115

Serial No/Batch: S113152

Revision: 6

Inspector:

Exp Date:

Instructions:

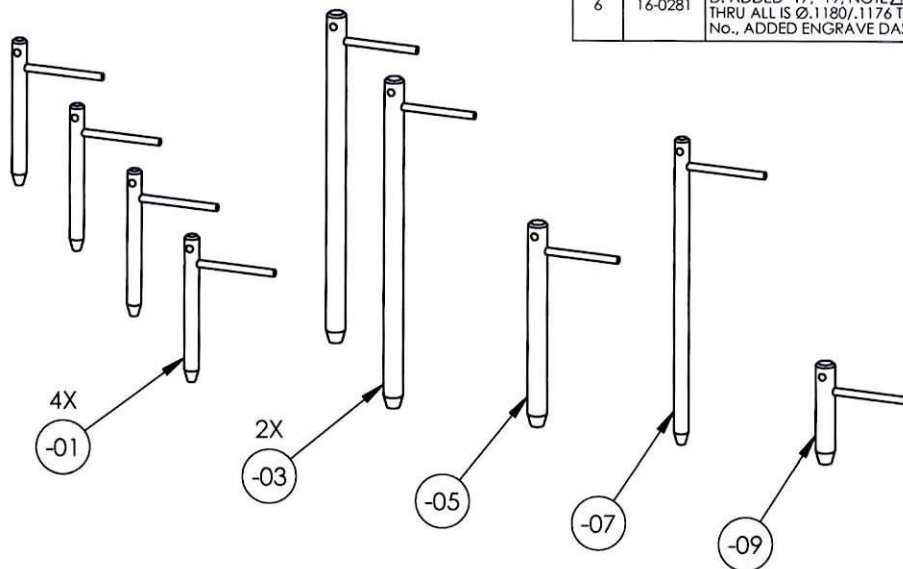
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Date: 09/24/18

Plex 6/28/18 4:20 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/11/2009	WP	DW
2		ADDED ONE MORE -03 PIN, FLAG AND CABLE TIE.	6/14/2010	WP	DW
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -01 THRU -09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	12/15/2010	RJC	RW
4		CORRECTED PIN VIEW SHEET 1 AND CH'D Ø.113 [Ø2.9mm] HOLE TO Ø.118 [Ø3.0mm] PER G.E.	5/9/2012	RJC	GE
4A		CH'D T/N WAS RBEA94-2706-00 IS RBE350A94-2706-00.	11/6/2013	RJC	RW
5	15-0120	UPDATED TO NEW DRAFTING STANDARDS. CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005. ADDED P/N'S -01A, -03A, -05A, -07A, -09A. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	5/26/2015	DPD	JAG
6	16-0281	UPDATED TO DRAFTING STANDARD. -01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE Δ. -01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 ±.001/-000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG

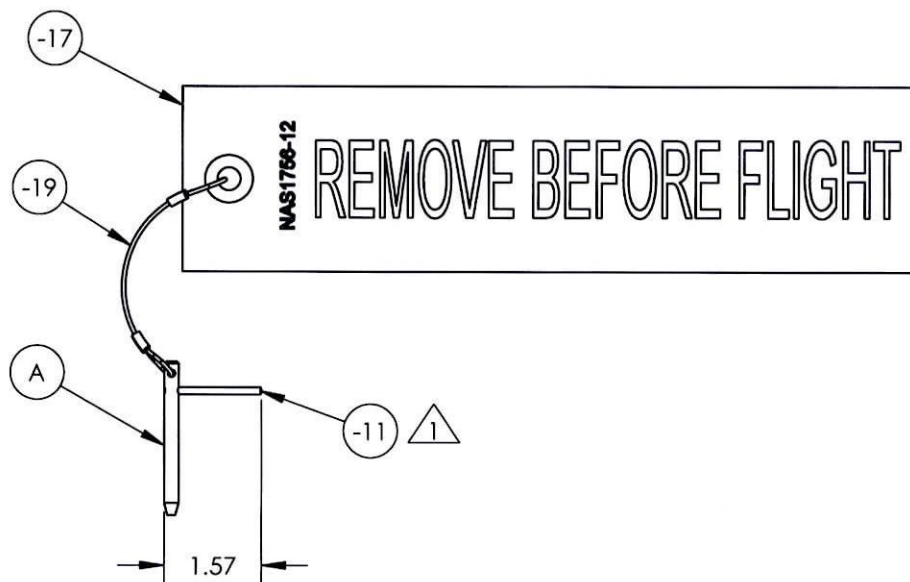
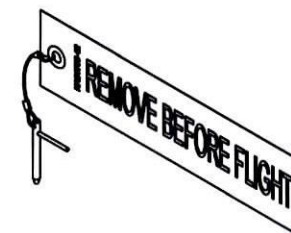


ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-01	4	PIN			2
				1		-01A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMaster-CARR #88625K65) MODIFIED	3
			X			-03	2	PIN			2
			1			-03A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMaster-CARR #88625K67) MODIFIED	3
		X				-05	1	PIN			2
		1				-05A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMaster-CARR #88625K67) MODIFIED	3
	X					-07	1	PIN			2
	1					-07A		PIN SHAFT	O-1	Ø6mm X 3 FT (MCMaster-CARR #88625K65) MODIFIED	3
X						-09	1	PIN			2
1						-09A		PIN SHAFT	O-1	Ø8mm X 3 FT (MCMaster-CARR #88625K67) MODIFIED	3
1	1	1	1	1	B/O	-11		DOWEL PIN	STEEL	Ø3mm X 40mm (MCMaster-CARR #91595A142)	2
					B/O	-13	1	RE-SEALABLE PLASTIC BAG		5 IN X 6 IN APPROX.	N/S
A/R	A/R	A/R	A/R	A/R	B/O	-15		LOCTITE 680			2
1	1	1	1	1	B/O	-17		FLAGS, REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
1	1	1	1	1	B/O	-19		CABLE TIE	BLACK NYLON	(MCMaster-CARR #7189K31)	2
ASSY -09	ASSY -07	ASSY -05	ASSY -03	ASSY -01							

		TITLE	
		RIGGING PIN SET	
DWG NO.		RBE350A94-2706-00	
		REV 6	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
		.X ± .1 SURFACES = 125/	
DRAWN BY:		PERRITT	
CHECKED:		DUERFELDT	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:3	
DATE		9/11/2009	
		SHEET 1 OF 3	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
6	16-0281	-01, -03, -05, -07, -09 ADDED FINISH SPEC QSMI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE Δ.			1/12/2017	RJC	JAG



ASSY P/N	A P/N
-01	-01A
-03	-03A
-05	-05A
-07	-07A
-09	-09A

NOTE:

1 USE LOCTITE 680 TO ASSEMBLE.

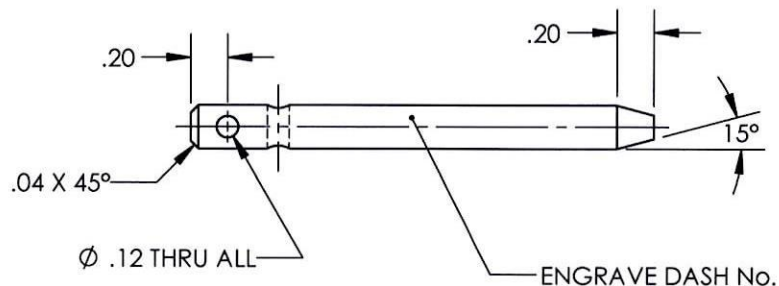
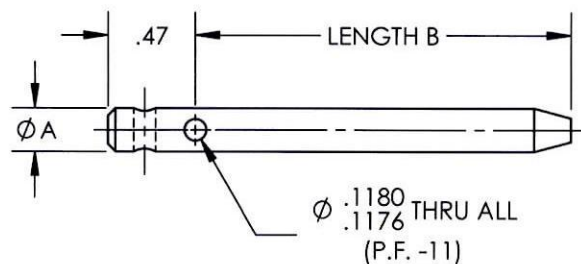
DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01	REV 6
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:3	DATE 9/11/2009 SHEET 2 OF 3

-01, -03, -05, -07, -09

PIN

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -.01 THRU -.09 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -.11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES. END OF PIN PER S.E.	5/26/2015	RJC	RW
4	15-0120	CH'D TOLERANCE BLOCK WAS .XXX ± .004 IS .XXX ± .005.	5/26/2015	DPD	JAG
6	16-0281	-01A, -03A, -05A, -07A, -09A CH'D DIM WAS 2X Ø.118 +.001/-0.000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -.11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



-01A, -03A, -05A, -07A, -09A

PIN SHAFT

ENGRAVE	PIN DIMENSION TABLE		
DASH No.	P/N	ØA	LENGTH B
-01	-01A	6mm	2.028
-03	-03A	8mm	5.177
-05	-05A	8mm	3.012
-07	-07A	6mm	4.783
-09	-09A	8mm	1.240

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01A	REV 6
MATL O-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -01, -03, -05, -07, -09	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .016R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:1	DATE 9/11/2009 SHEET 3 OF 3